

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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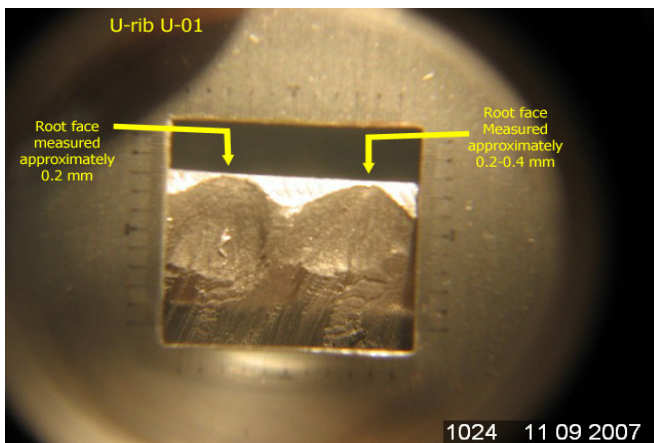
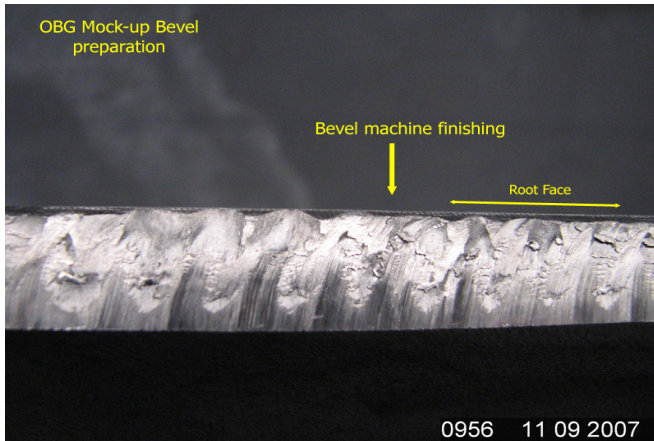
Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001237**Date Inspected:** 09-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu Yu Hong**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Item Description	WBS	Dwg No.	Status
1 Visual and Dimensional verifications of the Bevel Angles and Root Faces OBG Deck Mock-up			
The QA inspector performed visual and dimensional verifications for the bevel angles and the root faces for the Deck Mock-up (10 ribs, 5 ribs with approximately 13158 mm of length designated as U-01 through U-05 and 5 ribs with approximately 1750 mm of length designated as U-06 through U-10). The QA inspector found that bevel angles and root faces appeared to be in compliance with the contract documents however the QA inspector found that the roof faces had localized areas where the mill machine removed material resulting in root faces with less than 1 mm. The QA inspector representative informed Caltrans representative Chengwen Liu about the issue. The visual inspection of the root faces was still in process at the end of shift. ZPMC, ABF and Caltrans were aware of the issue and were discussing about the finishing of the root faces for OBG Deck Mock-up U-ribs bevel preparation and localized areas with less than 1 mm of root faces. See photographs below.			

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- 2 ZPMC bevel angle and root faces verifications on the OBG Deck Mock-up
- The QA inspector observed ZPMC performing bevel angle and root faces dimensional verifications.



Summary of Conversations:

As noted above

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials

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for your project.

Inspected By: Acuna,Alfredo

Quality Assurance Inspector

Reviewed By: Cuellar,Robert

QA Reviewer